

01-11-00 A

Docket No.  
769-197 CIP Div. 2Total Pages in this Submission  
52**UTILITY PATENT APPLICATION TRANSMITTAL  
(Large Entity)**

(Only for new nonprovisional applications under 37 CFR 1.53(b))

**TO THE ASSISTANT COMMISSIONER FOR PATENTS**Box Patent Application  
Washington, D.C. 20231

Transmitted herewith for filing under 35 U.S.C. 111(a) and 37 C.F.R. 1.53(b) is a new utility patent application for an invention entitled:

**ZIPPER STRIP AND METHOD OF POSITIONING THE STRIP TRANSVERSE LONGITUDINAL AXIS**

and invented by:

Art Malin, Donald Van Erden, James G. Kohl, Jr. and Michael McMahon

jc530 U.S.P.T.O.  
09/480061  
01/10/00

If a CONTINUATION APPLICATION, check appropriate box and supply the requisite information:

 Continuation  Divisional  Continuation-in-part (CIP) of prior application No.: 09/074,567

Which is a:

 Continuation  Divisional  Continuation-in-part (CIP) of prior application No.: 08/839,974

Which is a:

 Continuation  Divisional  Continuation-in-part (CIP) of prior application No.: 08/651,977

Enclosed are:

**Application Elements**

1.  Filing fee as calculated and transmitted as described below
  
2.  Specification having 19 pages and including the following:
  - a.  Descriptive Title of the Invention
  - b.  Cross References to Related Applications (*if applicable*)
  - c.  Statement Regarding Federally-sponsored Research/Development (*if applicable*)
  - d.  Reference to Microfiche Appendix (*if applicable*)
  - e.  Background of the Invention
  - f.  Brief Summary of the Invention
  - g.  Brief Description of the Drawings (*if drawings filed*)
  - h.  Detailed Description
  - i.  Claim(s) as Classified Below
  - j.  Abstract of the Disclosure

**UTILITY PATENT APPLICATION TRANSMITTAL  
(Large Entity)**

*(Only for new nonprovisional applications under 37 CFR 1.53(b))*

Docket No.  
769-197 CIP Div. 2

Total Pages in this Submission  
52

**Application Elements (Continued)**

3.  Drawing(s) (*when necessary as prescribed by 35 USC 113*)  
a.  Formal Number of Sheets \_\_\_\_\_ 7  
b.  Informal Number of Sheets \_\_\_\_\_

4.  Oath or Declaration  
a.  Newly executed (*original or copy*)  Unexecuted  
b.  Copy from a prior application (37 CFR 1.63(d)) (*for continuation/divisional application only*)  
c.  With Power of Attorney  Without Power of Attorney  
d.  **DELETION OF INVENTOR(S)**  
Signed statement attached deleting inventor(s) named in the prior application,  
see 37 C.F.R. 1.63(d)(2) and 1.33(b).

5.  Incorporation By Reference (*usable if Box 4b is checked*)  
The entire disclosure of the prior application, from which a copy of the oath or declaration is supplied under  
Box 4b, is considered as being part of the disclosure of the accompanying application and is hereby  
incorporated by reference therein.

6.  Computer Program in Microfiche (*Appendix*)

7.  Nucleotide and/or Amino Acid Sequence Submission (*if applicable, all must be included*)  
a.  Paper Copy  
b.  Computer Readable Copy (*identical to computer copy*)  
c.  Statement Verifying Identical Paper and Computer Readable Copy

**Accompanying Application Parts**

8.  Assignment Papers (*cover sheet & document(s)*)

9.  37 CFR 3.73(B) Statement (*when there is an assignee*)

10.  English Translation Document (*if applicable*)

11.  Information Disclosure Statement/PTO-1449  Copies of IDS Citations

12.  Preliminary Amendment

13.  Acknowledgment postcard

14.  Certificate of Mailing

First Class  Express Mail (*Specify Label No.:*) EK216245602US

**UTILITY PATENT APPLICATION TRANSMITTAL**  
**(Large Entity)**

(Only for new nonprovisional applications under 37 CFR 1.53(b))

Docket No.  
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 52

**Accompanying Application Parts (Continued)**

15.  Certified Copy of Priority Document(s) (*if foreign priority is claimed*)

16.  Additional Enclosures (*please identify below*):

Copy of Associate Power of Attorney from Parent Case  
 Copy of Preliminary Amendment from Parent Case

**Fee Calculation and Transmittal**

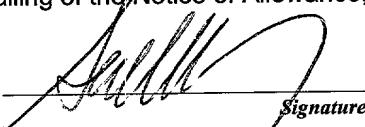
**CLAIMS AS FILED**

For	#Filed	#Allowed	#Extra	Rate	Fee
Total Claims	3	- 20 =	0	x \$18.00	\$0.00
Indep. Claims	1	- 3 =	0	x \$78.00	\$0.00
Multiple Dependent Claims (check if applicable)	<input type="checkbox"/>				
<b>BASIC FEE</b>					\$690.00
<b>OTHER FEE (specify purpose)</b>					\$40.00
<b>TOTAL FILING FEE</b>					\$730.00

A check in the amount of \_\_\_\_\_ to cover the filing fee is enclosed.

The Commissioner is hereby authorized to charge and credit Deposit Account No. 50-1145 as described below. A duplicate copy of this sheet is enclosed.

- Charge the amount of \$730.00 as filing fee.
- Credit any overpayment.
- Charge any additional filing fees required under 37 C.F.R. 1.16 and 1.17.
- Charge the issue fee set in 37 C.F.R. 1.18 at the mailing of the Notice of Allowance, pursuant to 37 C.F.R. 1.311(b).



Signature

Gerald Levy, Esq.  
 Reg. No. 24,419  
 PITNEY, HARDIN, KIPP & SZUCH LLP  
 711 Third Avenue  
 New York, New York 10017

Dated: January 10, 2000

(212)687-6000

cc:

**IN THE UNITED STATES PATENT AND TRADEMARK OFFICE**

Applicant: Art Malin, et al.

Serial No.: N/A

Filed: Herewith

Art Unit: 3721 (Parent Case)

For: **ZIPPER STRIP AND METHOD OF POSITIONING THE STRIP  
TRANSVERSE LONGITUDINAL AXIS**

Examiner: J. Calve (Parent Case)

711 Third Avenue  
New York, New York 10017  
(212) 687-6000

**PRELIMINARY AMENDMENT**

Assistant Commissioner for Patents  
Washington, D.C. 20231

SIR:

Prior to any action in the above captioned case, kindly amend the application as follows:

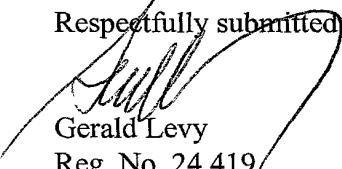
**In the claims:**

Cancel claims 1 - 13.

**Remarks**

The present amendment is being submitted herewith to cancel all of the claims of the parent case, except for claims 14 - 16 for prosecution in the divisional application filed herewith.

An early action on the merits is respectfully requested.

Respectfully submitted  
  
Gerald Levy  
Reg. No. 24,419

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant: Art Malin et al.  
Filed: Herewith  
Art Unit: 3721 (Parent Case)  
Examiner: Calve, J. (Parent Case)  
For: ZIPPER STRIP AND METHOD OF POSITIONING  
THE STRIP TRANSVERSE LONGITUDINAL AXIS

711 Third Avenue  
New York, New York 10017  
(212) 687-6000

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents  
Washington, D.C. 20231

S I R:

Prior to any action in the above captioned application,  
kindly amend the above captioned application as follows:

In the specification:

Please delete the first sentence of the specification and substitute the following sentence therefor:

--This is a division of U.S. Patent Application Serial No. 08/839,974 filed on April 24, 1997, which application is a continuation-in-part (CIP) of U.S. Patent Application Serial No. 08/651,977 filed on May 21, 1996.--

Page 12, line 1, change "one" to --on--.

Page 13, line 12, insert --a package-- before "110".

In the claims:

Please cancel claims 1, 2 and 3.

Please amend claim 4 as follows:

4. (Amended) A method for attaching a zipper strip transversely on a sheet of thermoplastic sheet material during the production of plastic bags or packages having transverse zippers on a form-fill-and-seal machine, said sheet being advanced in amounts equal in length to that of the bags or packages being manufactured, a length of zipper strip being attached each time said sheet is brought to rest, said method comprising the steps of:

providing a zipper strip having interlocked male and female interlocking profiles, one of said male and female interlocking profiles having a web wider than that of the other on at least

one of two lateral side thereof, the greater width of the wider web being at least one flange running therealong;

15 disposing a length of said zipper strip transversely upon said sheet of thermoplastic sheet material, said one of said male and female interlocking profiles having said wider web being in contact with said sheet [and said at least one flange being oriented in the direction of the motion of said sheet]; and

20 sealing said at least one flange onto said sheet of thermoplastic material without sealing said webs of said male and female interlocking profiles to each other.

Please add the following new claims:

11. (New) A method as claimed in claim 4 wherein said at least one flange is oriented in the direction of the motion of said sheet.

12. (New) A method of making reclosable packages comprising the steps of:

5 providing a sheet of thermoplastic sheet material and advancing said thermoplastic sheet material in amounts equal in length to that of said packages;

providing a zipper strip having interlocked male and female interlocking profiles, one of said male and female interlocking profiles having a web wider than that of the other on at least one of two lateral side thereof, the greater width of the wider web being at least one flange running therealong;

disposing a length of said zipper strip transversely upon  
said sheet of thermoplastic sheet material, said one of said male  
and female interlocking profiles having said wider web being in  
contact with said sheet and being oriented in the direction of  
15 the motion of said sheet;

sealing said at least one flange to said sheet of  
thermoplastic material;

forming a package; and

thereafter sealing said webs of said male and female  
20 interlocking profiles to said package without sealing said webs  
to each other.

13. (New) A method of making reclosable packages comprising  
the steps of:

providing a sheet of thermoplastic sheet material having two  
lateral edges and advancing said thermoplastic sheet material in  
amounts equal in length to that of said packages;

providing a zipper strip having interlocked male and female  
interlocking profiles, one of said male and female interlocking  
profiles having a web wider than that of the other on at least  
one of two lateral side thereof, the greater width of the wider  
10 web being at least one flange running therealong;

disposing a length of said zipper strip transversely upon  
said sheet of thermoplastic sheet material, said one of said male  
and female interlocking profiles having said wider web being in  
contact with said sheet and being oriented in the direction of

15 the motion of said sheet;  
sealing said at least one flange to said sheet of  
thermoplastic sheet material;  
folding said thermoplastic sheet material so as to bring  
said lateral edges together;  
20 sealing said lateral edges together to form a tube;  
sealing said tube to said length of zipper strip without  
sealing said webs of said male and female interlocking profiles  
to each other; and  
cutting said package to remove a completed package from said  
25 tube.

14. (New) A reclosable package comprising:  
a first wall and a second wall opposite said first wall;  
a zipper strip for selectively opening and closing said  
package, said zipper strip comprising a male interlocking profile  
5 extending along an internal surface of said first wall and a  
female interlocking profile extending along an internal surface  
of said second wall;  
said male interlocking profile having a male interlocking  
member and a male web integral therewith;  
10 said female interlocking profile having a female  
interlocking member and a female web integral therewith, said  
male interlocking member being engagable within said female  
interlocking member to join said male and female interlocking  
profiles together;

15       wherein one of said male and female webs is wider than the  
other of said male and female webs in at least one of two  
directions from said male and female interlocking members, the  
greater width of the wider of said male and female webs being at  
least one flange extending widthwise beyond the other of said  
20      male and female webs;

          wherein said at least one flange is sealed to one of said  
package walls at a first seal area; and

          wherein the other interlocking profile is sealed to the  
other package wall at a second seal area spaced apart from said  
25      first seal area along the width of said zipper strip.

15. (New) A reclosable package according to claim 14 wherein  
said at least one flange is sealed to only one of said package  
walls.

16. (New) A reclosable package according to claim 15 wherein  
a portion of the interlocking profile having said wider web which  
is not said at least one flange is separately sealed to the same  
package wall as said at least one flange.

Remarks

The present application is a division of U.S. Patent Application Serial No. 08/839,974 filed on April 24, 1997, which application is a continuation-in-part (CIP) of U.S. Patent Application Serial No. 08/651,977 filed on May 21, 1996. Accordingly, the specification has been amended to make reference to the parent application and to cancel the claims directed at the zipper strip and leave for consideration the claims directed at the method for attaching the zipper strip to thermoplastic sheet material and the method for making reclosable packages.

The application has also been amended to clarify the claims and to add new claims which give the Applicant the full scope of patent protection to which it is entitled.

Claim 4 as originally drafted was unnecessarily limited by requiring the flange to be oriented in the direction of motion of the thermoplastic sheet. Accordingly, this limitation has been deleted from claim 4 and has been incorporated into new independent claim 11. It is believed that claims 4 and 11 as amended herein are patentably distinguishable from the prior art.

New claims 12 and 13 have been added which are directed at alternate methods of making a reclosable package. Both claims are clearly supported by the specification and no new matter has been added. It is believed that claims 12 and 13 are patentably

distinguishable from the prior art.

New claims 14, 15 and 16 have been added which are directed at the reclosable package of Figure 8. All three claims are clearly supported by the specification and no new matter has been added. It is believed that claims 14, 15 and 16 are patentably distinguishable from the prior art.

An early action and early indication of allowance are respectfully requested.

Respectfully submitted,

  
\_\_\_\_\_  
Gerald Levy  
24, 419

**Zipper Strip and Method of Positioning  
the Strip Transverse Longitudinal Axis**

**CROSS REFERENCE TO RELATED APPLICATIONS**

This is a continuation-in-part (CIP) of U.S. Patent Application Serial No. 08/651,977 filed on May 21, 1996.

**Background of the Invention**

**1. Field of the Invention**

The present invention relates to reclosable plastic bags of the type in which perishable food products and other goods are packaged for sale to consumers in retail outlets. More specifically, the present invention relates to reclosable plastic bags manufactured and concurrently filled on horizontal or vertical form-fill-and-seal (FFS) machines, wherein a plastic interlocking zipper for each bag is disposed transversely relative to the direction of motion of the thermoplastic sheet material used to form the reclosable bags on the FFS machine.

**2. Description of the Prior Art**

The present invention relates to improvements in the package-making art and may be practiced in the manufacture of thermoplastic bags and packages of the kind that may be used for various consumer products, but which are particularly useful for food products which must be kept in moisture- and air-tight packages, free from leakage until initially opened for access to the product contents, which packages are then reclosable by zipper means to protect any remainder of the product therein.

The indicated art is fairly well-developed, but nevertheless remains susceptible to improvement contributing to increased efficiency and cost effectiveness.

5 One problem that still hampers the production of packages from continuous zipper-equipped sheet material is the difficulty in attaining a satisfactory sealing of the bag or package against leakage, where the zipper and area of film engaged by the zipper  
10 extends through the side (cross) seal areas separating one bag or package from the next. This problem occurs where the zipper is longitudinal with respect to the direction of motion of the thermoplastic sheet material used to form the reclosable bags on the FFS  
15 machine, in which case the transverse, or side, sealing bars must flatten and seal the zipper at the same time as they are sealing the thermoplastic sheet material from which the packages are being made. The difficulty with which this is consistently and  
20 successfully achieved is reflected by the high occurrence of leaking packages.

Numerous attempts have been made to solve this problem. Among the approaches that have been taken is the substitution of a transverse zipper for the longitudinal zipper. Where such a zipper is provided the transverse sealing bars associated with the FFS  
25 machine do not flatten the zipper as they are making a side seal, although they may seal the zipper to the thermoplastic sheet material transversely thereacross  
30 without flattening it.

The present invention relates to the provision of a transverse zipper for reclosable plastic bags or packages being manufactured on either a horizontal or vertical FFS machine. More specifically, the present  
35 invention is both a zipper strip and a method for

securing the zipper strip transversely across the thermoplastic sheet material from which reclosable bags are being produced on a FFS machine.

Summary of the Invention

5 Accordingly, the present invention is a zipper strip for a reclosable bag or package manufactured and filled using a form-fill-and-seal machine. In particular, the zipper strip is designed to be disposed transversely with respect to the movement  
10 through the machine of the thermoplastic sheet material used to fashion the packages.

The zipper strip comprises a male interlocking profile, having a male interlocking member and a male web coextruded therewith; and a female interlocking profile, having a female interlocking member and a female web coextruded therewith. The male interlocking member is snappingly engagable within the female interlocking member to join the male and female interlocking profiles together.  
15

20 One of the male and female webs is wider than the other of the male and female webs in at least one of two directions from the male and female interlocking members in the closed zipper strip. The greater width of the wider of the male and female webs means that it  
25 has a flange extending beyond the other web on one and possibly both sides. The zipper strip, as a consequence, may be attached transversely upon thermoplastic sheet material by sealing the flange of the male or female web or flanges thereto without  
30 sealing the male and female webs to each other.

The present invention also comprises a method for attaching this zipper strip transversely on a sheet of

thermoplastic sheet material during the production of plastic bags or packages on an FFS machine. In this situation, a length of the zipper strip is attached to the thermoplastic sheet material, each time it is brought to rest as it advances (incrementally or continuously) on or to the FFS machine.

This method includes the step of providing a zipper strip of the above-described variety. The length of zipper strip is then disposed transversely upon the sheet of thermoplastic sheet material, with the wider of the male and female webs in contact with the sheet and with a flange, or the flange if there is only one, oriented in the direction of the motion of the sheet. The flange or flanges are then sealed to the sheet without sealing the male and female webs to each other. Several specific ways of disposing the length of zipper strip onto the sheet of thermoplastic sheet material will be described below.

Finally, the present invention comprises a method for manufacturing reclosable packages on a horizontal form-fill-and-seal machine. The method includes the step of providing a sheet of thermoplastic sheet material having a length of zipper strip attached thereto at regularly spaced intervals as described above. A product conveyor then deposits a product to be packaged at regular intervals onto the sheet of thermoplastic sheet material. The two lateral edges of the sheet are then folded toward one another and around the product, and sealed to one another to form a tube therefrom enclosing the product.

The tube is then sealed transversely to each length of zipper strip without the webs of the male and female interlocking profiles being sealed to each other. The tube is then cut transversely adjacent to

each length of zipper strip to separate each completed package from the next.

The present inventions will now be described in more complete detail with frequent reference being 5 made to the figures identified below.

Brief Description of the Drawings

Figure 1 is a cross-sectional view of a first embodiment of the zipper strip of the present invention;

10 Figure 2 is a cross-sectional view of a second embodiment of the zipper strip;

Figure 3 is a perspective view of an apparatus used to attach the zipper strip to thermoplastic sheet material;

15 Figure 4 is a perspective view of an alternate apparatus used for this purpose;

Figure 5 is a perspective view of still another apparatus used for this purpose;

20 Figure 6 is a schematic view of a horizontal FFS machine;

Figure 7 is a plan view of the thermoplastic sheet material, with lengths of zipper strip attached thereto, used to produce packages on the horizontal FFS machine; and

25 Figure 8 is a simplified cross-sectional view of a package formed in a horizontal FFS machine in accordance with the present invention.

Detailed Description of the Preferred Embodiments

Referring specifically to the figures identified 30 above, Figure 1 is a cross-sectional view of a first embodiment of the zipper strip 10 of the present invention. The zipper strip 10 comprises a male

interlocking profile 12 and a female interlocking profile 14. The male interlocking profile 12 includes a male interlocking member 16 which may have an arrowhead-shaped cross section or, as is shown in  
5 Figure 1, an asymmetrical arrowhead-shaped cross section, designed to make the zipper strip 10 easier to open from one side than from the other. The female interlocking profile 14 includes a female interlocking member 18 comprising two inwardly curving members  
10 forming a receptacle or channel into which male interlocking member 16 may be snappingly engaged.

Both the male and female interlocking profiles 12, 14 include webs coextruded with the male and female interlocking members 16, 18. Web 20 of male interlocking profile 12, it may be observed, is wider than web 22 of female interlocking profile 14. As a consequence, web 20 has a leading flange 24 and a trailing flange 26, which together make up the amount by which web 20 is wider than web 22. As will become  
15 clear below, the leading and trailing flanges 24, 26 are so called because, when zipper strip 10 is attached to a thermoplastic sheet material being fed into an FFS machine, the leading flange 24 "leads" the transversely attached zipper strip 10 toward the  
20 machine, and the trailing flange 26 "trails" or is last. Ultimately, the leading flange 24 resides inward of the mouths of the plastic bags or packages being manufactured and concurrently filled with a consumer product on an FFS machine. While the male  
25 interlocking profile 12 is shown to have both the leading and trailing flanges 24, 26, both flanges 24, 26 could alternatively be part of the female interlocking profile 14 instead.

The zipper strip 10 is disposed transversely  
30 across thermoplastic sheet material during the

manufacture of plastic bags or packages on an FFS machine. The zipper strip 10 is dispensed with male and female interlocking profiles 12, 14 joined as shown in Figure 1 onto thermoplastic sheet material 5 with the male interlocking profile 12 resting thereupon. Heat seal bars 28 or the like, applied against the leading and trailing flanges 24, 26 as suggested by the arrows in Figure 1, seal the male interlocking profile 12 to the thermoplastic sheet 10 material (not shown) without sealing web 22 of the female interlocking profile 14 to web 20 of the male interlocking profile 12.

Heat seal materials 30 may be applied to the outside of web 20 of male interlocking profile 12, 15 including the outsides of the leading and trailing flanges 24, 26, as well as to the inside of the trailing flange 26 and to the outside of web 22 of the female interlocking profile 14, to facilitate their being sealed to thermoplastic sheet material. The 20 trailing flange 26 may also be separable from the rest of web 20 by perforations.

The outsides of the leading and trailing flanges 24, 26 are attached to thermoplastic sheet material before the sheet material reaches the shoulder on a 25 vertical FFS machine, or before the sheet material enters the FFS machine. Later, when the sheet material is folded over to form a tube with lateral edges sealed in a fin or overlap seal, the sheet material is sealed to the inside of trailing flange 30 26, as well as to the outsides of both webs 20, 22, without sealing the facing portions of webs 20, 22 to one another.

Figure 2 is a cross-sectional view of a second embodiment of the zipper strip 40 of the present 35 invention. Elements common to both zipper strip 40

and zipper strip 10 described above are identified in Figure 2 using the same reference numbers. A comparison between Figures 1 and 2 indicates that zipper strip 40 lacks a trailing flange 26, but is  
5 identical to zipper strip 10 in all other respects. As was the case with zipper strip 10, zipper strip 40 is disposed transversely across thermoplastic sheet material during the manufacture of plastic bags or packages on an FFS machine. Male interlocking profile 42 rests upon the thermoplastic sheet material. Heat seal bars 28 or the like, applied against the leading flange 24, as suggested by the arrows in Figure 2, seal the male interlocking profile 42 to the thermoplastic sheet material (not shown) without  
10 sealing web 22 of the female interlocking profile 14 to web 44 of the male interlocking profile 42. As before, while the male interlocking profile 42 is shown to have the leading flange 24, leading flange 24 could alternatively be part of the female interlocking  
15 profile 14 instead.  
20

Both zipper strips 10, 40 shown in Figures 1 and 2, respectively, may be extruded from a polymeric resin material, such as a low-density polyethylene (LDPE). Heat seal materials 30 may be applied as  
25 shown by coextrusion or by coating following the extrusion of zipper strips 10, 40. Ethylene vinyl acetate (EVA) copolymers may be used as the heat seal materials 30.

Figure 3 is a perspective view of an apparatus  
30 used to attach zipper strip 10 to thermoplastic sheet material 50, which is conveyed in the direction of the arrows thereon toward an FFS machine. Thermoplastic sheet material 50 is moved intermittently in increments equal in length to the length of the  
35 packages being produced.

Each time the thermoplastic sheet material 50 is momentarily brought to rest, a length of zipper strip 10 is sealed transversely across the upwardly facing side thereof. Zipper tape 10 is dispensed from a roll or other supply not shown in Figure 3, and fed through a stationary clamp 52, and through a reciprocating shuttle 54, which includes a clamp 56 and a guillotine 58, the latter of which is used to cut the zipper strip 10 when required.

Shuttle 54 reciprocates each time the thermoplastic sheet material 50 is momentarily brought to rest. When shuttle 54 moves outward over thermoplastic sheet material 50, clamp 56 is closed onto zipper tape 10, while stationary clamp 52 is open, so that shuttle 54 pulls a length of the zipper tape 10 from the roll. The outward end of shuttle 54 is a probe 60, which allows the leading flange 24 and the trailing flange 26 of the zipper tape 10 to protrude from the sides thereof.

As shown in Figure 3, the shuttle 54 is in its retracted position. When in its forward position, not shown, the probe 60 extends into the space between the top sealing jaw 62 and its corresponding bottom sealing jaw 64, the latter of which is on the underside of the thermoplastic sheet material 50. The leading and trailing flanges 24, 26 extend outward from between the top and bottom sealing jaws 62, 64. When the jaws 62, 64 close, heat seal bars 28 seal the flanges 24, 26 to the thermoplastic sheet material 50. Jaws 62, 64 then are opened; guillotine 58 cuts the next length of zipper strip 10; clamp 56 is opened; and clamp 52 is closed. Then shuttle 54 retracts to the position shown in Figure 3, while thermoplastic sheet material 50 moves a length equal to the length of a package being manufactured to repeat the process.

Figure 4 is a perspective view of an alternate apparatus used to attach zipper strip 10 to thermoplastic sheet material 50. As before, thermoplastic sheet material 50 is conveyed in the direction of the arrow thereon toward an FFS machine, and is moved intermittently in increments equal in length to the length of the packages being produced.

Again, each time the thermoplastic sheet material 50 is momentarily brought to rest, a length of zipper strip 10 is sealed transversely across the upwardly facing side thereof. Zipper strip 10 is dispensed from a roll or other supply not shown in Figure 4, being pulled therefrom by a first clamp 70, which reciprocates back and forth along mechanism 74 in step with a second clamp 72. First and second clamps 70, 72 grasp leading flange 24 of zipper strip 10 to pull the zipper strip 10 transversely across the thermoplastic sheet material. Second clamp 72 holds the zipper strip 10 in position while it is being sealed to the upwardly facing side of the thermoplastic sheet material 50. A stationary guillotine 76 is used to cut the zipper strip 10 when required.

Each time the thermoplastic sheet material 50 is momentarily brought to rest, second clamp 72 brings a length of zipper strip 10 cut by stationary guillotine 76 transversely outward thereover to the position shown in Figure 4. At the same time, first clamp 70, moving in step with second clamp 72, moves a length of zipper strip 10 through guillotine 76. Top sealing jaw 62 and its corresponding bottom sealing jaw 64, the latter of which is on the underside of the thermoplastic sheet material 50, seal the leading flange 24 and the trailing flange 26 of the zipper strip 10 thereto, while the second clamp 72 holds onto

the leading flange 24. Then, first clamp 70 and second clamp 72 retract from the positions shown in Figure 4, the first clamp 70 retracting to a position adjacent to guillotine 76, and the second clamp 72 5 retracting upstream from the guillotine 76 along zipper strip 10. Thermoplastic sheet material 50 then moves a length equal to the length of a package being manufactured to repeat the process.

Figure 5 is a perspective view of another 10 apparatus used to attach zipper strip 10 to thermoplastic sheet material 50. Thermoplastic sheet material 50 is conveyed in the direction of the arrow thereon toward an FFS machine, and, as before, is moved intermittently in increments equal in length to 15 the length of the packages being produced.

Again, each time the thermoplastic sheet material 50 is momentarily brought to rest, a length of zipper strip 10 is sealed transversely across the upwardly facing side thereof. Zipper strip 10 is dispensed 20 from a roll or other supply not shown in Figure 5, being pulled therefrom by a perforated belt 80 entrained about chambers 82, 84 attached to a vacuum or suction. Suction through the perforated belt 80 is used to transport the zipper strip 10. A stationary 25 guillotine 86, through which the zipper strip 10 passes, is used to cut the zipper strip 10 when required.

Each time the thermoplastic sheet material 50 is 30 momentarily brought to rest, perforated belt 80 draws a length of zipper strip 10 transversely across thermoplastic sheet material 50. The leading flange 24 and the trailing flange 26 of the zipper strip 10 extend beyond the two sides of the perforated belt 80 and chamber 82, which extend into the space between 35 the top sealing jaw 62 and its corresponding bottom

sealing jaw 64, the latter of which is one the underside of the thermoplastic sheet material 50. The leading and trailing flanges 24, 26 extend outward from between the top and bottom sealing jaws 62, 64.

5 The vacuum is turned off. When the jaws 62, 64 close, heat seal bars 28 seal the flanges 24, 26 to the thermoplastic sheet material. The jaws 62, 64 are then opened, and the thermoplastic sheet material 50 is moved a length equal to the length of a package being manufactured. The vacuum is then turned on; guillotine 86 cuts the zipper strip 10; and the perforated belt 80 draws the portion of zipper strip 10 transversely across the thermoplastic sheet material 50 to repeat the process.

15 Any of these preceding apparatus for attaching a zipper strip 10 to thermoplastic sheet material 50 may be used in the manufacture of packages on a horizontal or vertical FFS machine. In this regard, Figure 6 is a schematic view of a horizontal apparatus. A roll 90 of thermoplastic sheet material 50 dispenses the sheet 50 intermittently in lengths equal to that of the packages being manufactured and filled. A length of zipper strip 10 is applied by the zipper applicator 92, which may include any of the three apparatus described, to the center of the sheet material 50, as shown in Figure 7, leaving sufficient material along the two lateral edges 96 of the sheet material 50 to fold over toward one another for joining in an overlap or fin seam.

30 An accumulator 94 is used to convert the intermittent motion of the thermoplastic sheet material 50 to a continuous motion.

A product conveyor 98 carries the product 99 to be packaged toward the wrapping machine 100, which comprises a forming area 102, a sealing area 104, and

a cross-seal area 106. In the forming area 102, the two lateral edges 96 of the sheet material 50 are folded upward and around the product. In the sealing area 104, the two lateral edges 96 are sealed to one another with a fin or lap seal to form a continuous film tube with the product and zipper strips 10 inside. In the cross-seal area, the webs of the zipper strip 10 are sealed to the sheet material 50, without sealing the webs to each other, and the packages are separated from one another along lines 112, and carried onward by the takeaway conveyor 108.

Fig. 8 depicts 110 formed in accordance with the above and containing therein the product 99. In this package the top (wide) flange 26 of one of the profiles is sealed to the portions of the film web forming the package bottom 114 as well as the package top 116. The other wide flange 24 of that profile is secured to the portions of the film web forming the package bottom 114 while the narrow flange 22 of the other profile is secured only to the portions of the film web forming the package top 116.

Modifications to the above would be obvious to those of ordinary skill in the art, but would not bring the invention so modified beyond the scope of the appended claims.

What Is Claimed Is:

1. A zipper strip for a reclosable bag or package, said zipper strip comprising:

a male interlocking profile, said male interlocking profile having a male interlocking member and a male web extruded therewith; and

5 a female interlocking profile, said female interlocking profile having a female interlocking member and a female web coextruded therewith, said male interlocking member being snappingly engagable within said female interlocking member to join said male and female interlocking profiles together,

10 wherein one of said male and female webs is wider than the other of said male and female webs in at least one of two directions from said male and female interlocking members, the greater width of the wider of said male and female webs being at least one flange extending widthwise beyond the other of said male and female webs,

15 so that said zipper strip may be attached to thermoplastic sheet material by sealing said at least one flange thereto without sealing said male and female webs to each other.

20

2. A zipper strip as claimed in claim 1 wherein one of said male and female webs is wider than the other of said male and female webs in only one of said two directions from said male and female interlocking members, the greater width of the wider of said male and female webs being a flange extending beyond the other of said male and female webs in said one of said two directions.

3. A zipper strip as claimed in claim 1 wherein one of said male and female webs is wider than the other of said male and female webs in both of said two directions from said male and female interlocking members, the greater width of the wider of said male and female webs being two flanges extending beyond the other of said male and female webs in opposite directions from said male and female interlocking members.

4. A method for attaching a zipper strip transversely on a sheet of thermoplastic sheet material during the production of plastic bags or packages having transverse zippers on a form-fill-and-seal machine, said sheet being advanced in amounts equal in length to that of the bags or packages being manufactured, a length of zipper strip being attached each time said sheet is brought to rest, said method comprising the steps of:

10 providing a zipper strip having interlocked male and female interlocking profiles, one of said male and female interlocking profiles having a web wider than that of the other on at least one of two lateral side thereof, the greater width of the wider web being at least one flange running therealong;

15 disposing a length of said zipper strip transversely upon said sheet of thermoplastic sheet material, said one of said male and female interlocking profiles having said wider web being in contact with said sheet and said at least one flange being oriented in the direction of the motion of said sheet; and

20 sealing said at least one flange onto said sheet of thermoplastic material without sealing said webs of

25 said male and female interlocking profiles to each other.

5. A method as claimed in claim 4 wherein one of said male and female interlocking profiles has a web wider than that of the other on both of two lateral sides thereof, the greater width of the wider web  
5 being a flange running along each lateral side thereof.

6. A method as claimed in claim 4 wherein the step of disposing a length of said zipper strip transversely upon said sheet of thermoplastic sheet material is performed by a reciprocating shuttle having a clamp and a guillotine, said clamp being provided to pull said zipper strip from a supply transversely onto said sheet, and said guillotine being provided to cut said length of said zipper strip.

7. A method as claimed in claim 4 wherein the step of disposing a length of said zipper strip transversely upon said sheet of thermoplastic sheet material is performed by a pair of reciprocating clamps separated by a stationary guillotine, both of said reciprocating clamps grasping said zipper strip by said at least one flange thereof, one of said reciprocating clamps transferring said length of zipper strip cut by said guillotine onto said sheet of  
5 thermoplastic sheet material and holding said length during said sealing step, and the other of said reciprocating clamps pulling said zipper strip from a supply thereof toward said guillotine.  
10

8. A method as claimed in claim 4 wherein the step  
of disposing a length of said zipper strip  
transversely upon said sheet of thermoplastic sheet  
material is performed by a vacuum conveyor means and  
5 a guillotine, said vacuum conveyor means pulling said  
zipper strip from a supply thereof and pulling lengths  
cut by said guillotine onto said sheet of  
thermoplastic sheet material.

9. A method as claimed in claim 4 wherein the motion  
of the sheet is incremental.

10. A method for manufacturing reclosable packages on  
a horizontal form-fill-and-seal machine, said method  
comprising the steps of:

providing a sheet of thermoplastic sheet material  
5 having at regular intervals therealong a length of  
zipper strip attached transversely across the center  
thereof and having strips without zipper strip along  
two lateral edges thereof, said zipper strip having  
interlocked male and female interlocking profiles, one  
10 of said male and female interlocking profiles having  
a web wider than that of the other on at least one of  
two lateral sides thereof, the greater width of the  
wider web being at least one flange running  
therealong, said one of said male and female  
15 interlocking profiles having said wider web being  
attached to said sheet, said at least one flange being  
oriented in a direction of motion of said sheet on  
said horizontal form-fill-and-seal machine, said at  
least one flange being sealed to said sheet to attach  
20 said interlocked male and female interlocking profiles  
thereto;

providing a product conveyor to deposit a product to be packaged onto said sheet of thermoplastic sheet material;

25        folding said two lateral edges of said sheet of thermoplastic sheet material toward one another and around said product;

30        sealing said two lateral edges of said sheet to one another to form a tube therefrom enclosing said product;

              sealing said tube transversely to each said length of zipper strip without sealing said webs of said male and female interlocking profiles to each other; and

35        cutting said sealed tube to separate each completed package from the next.

Abstract of the Disclosure

A zipper strip for a reclosable bag or package includes a male interlocking profile and a female interlocking profile. The male interlocking profile includes a male interlocking member and a male web coextruded therewith. In like manner, the female interlocking profile includes a female interlocking member and a female web. The male interlocking member snappingly engages into the female interlocking member to join the profiles to one another. One of the male and female webs is wider than the other in at least one of two directions from the male and female interlocking members, the greater width being represented by at least one flange extending widthwise beyond the other web. The zipper strip is designed to be attached to thermoplastic sheet material by sealing the at least one flange thereto without sealing the male and female webs to each other. Methods for securing the zipper strip to thermoplastic sheet material, and for making packages on a horizontal form-fill-and-seal machine, are also disclosed.

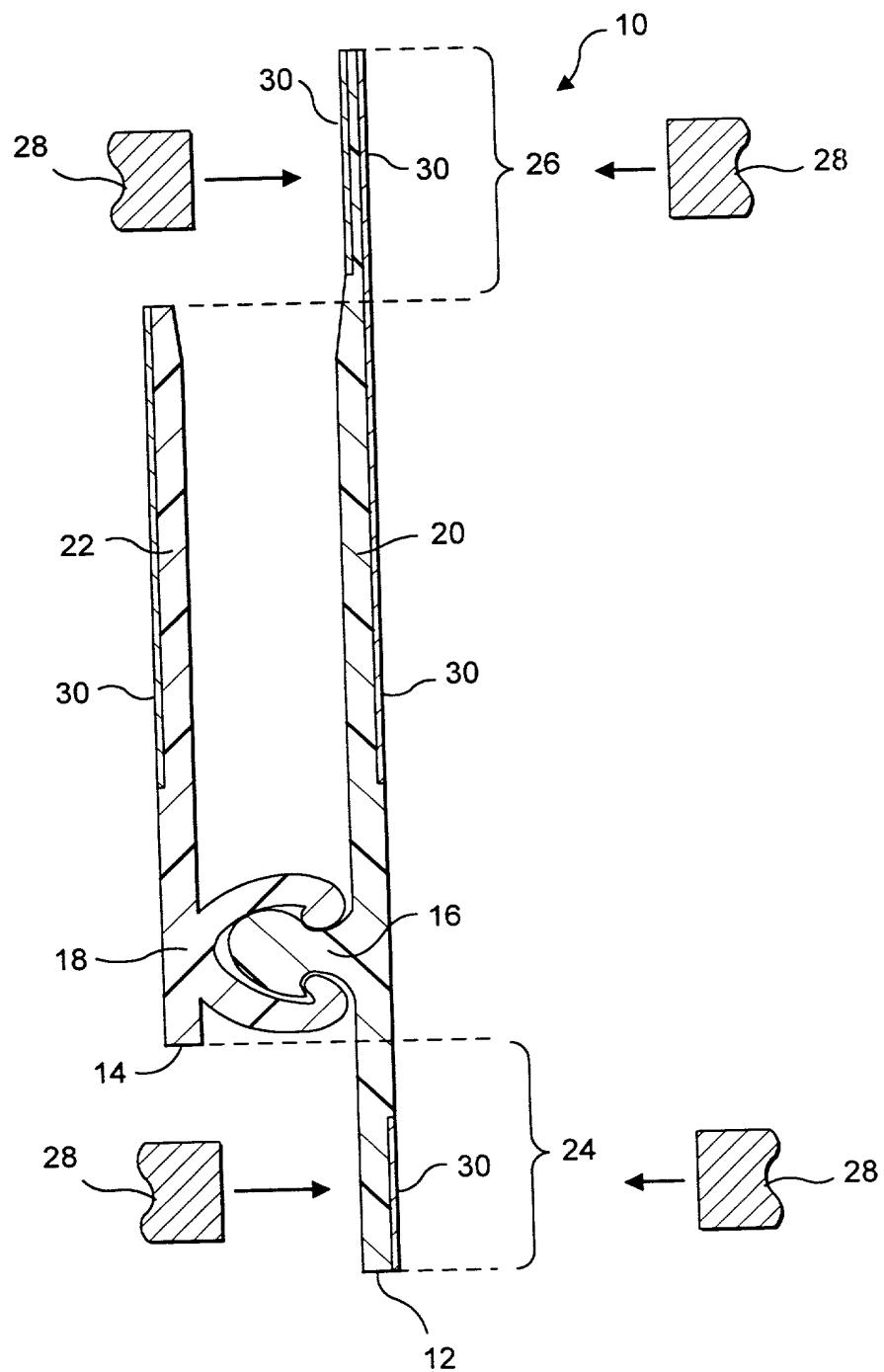


FIG. 1

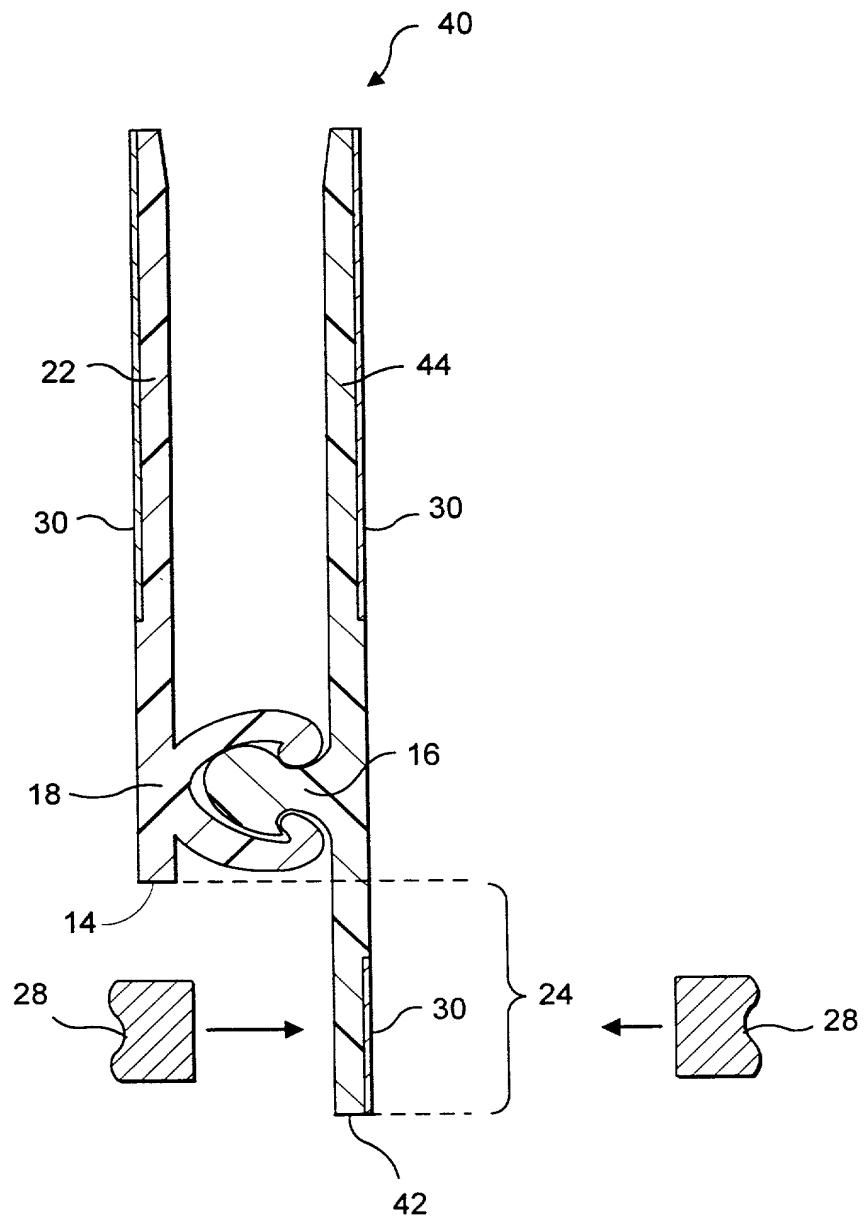


FIG. 2

FIG. 3

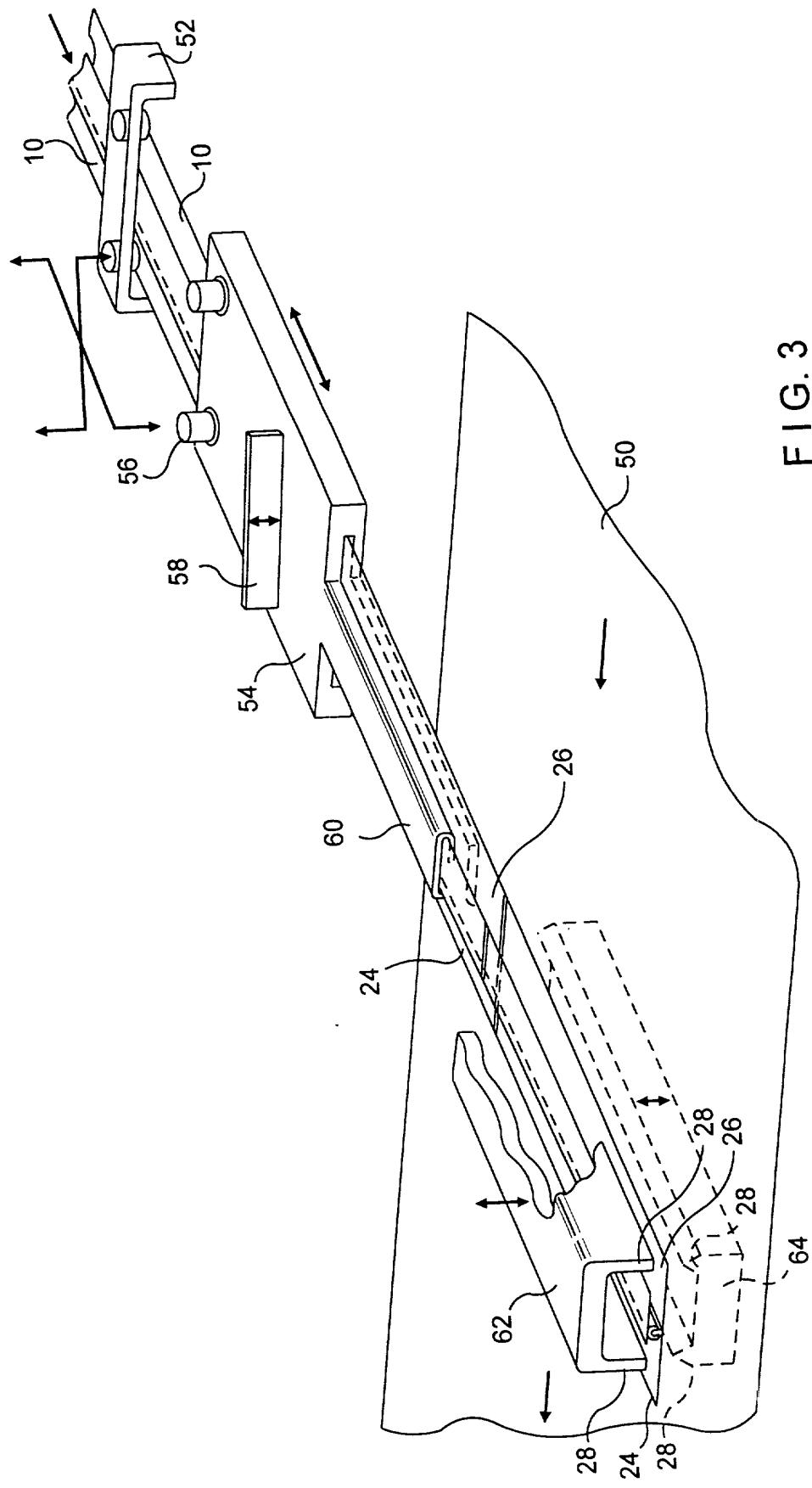


FIG. 4

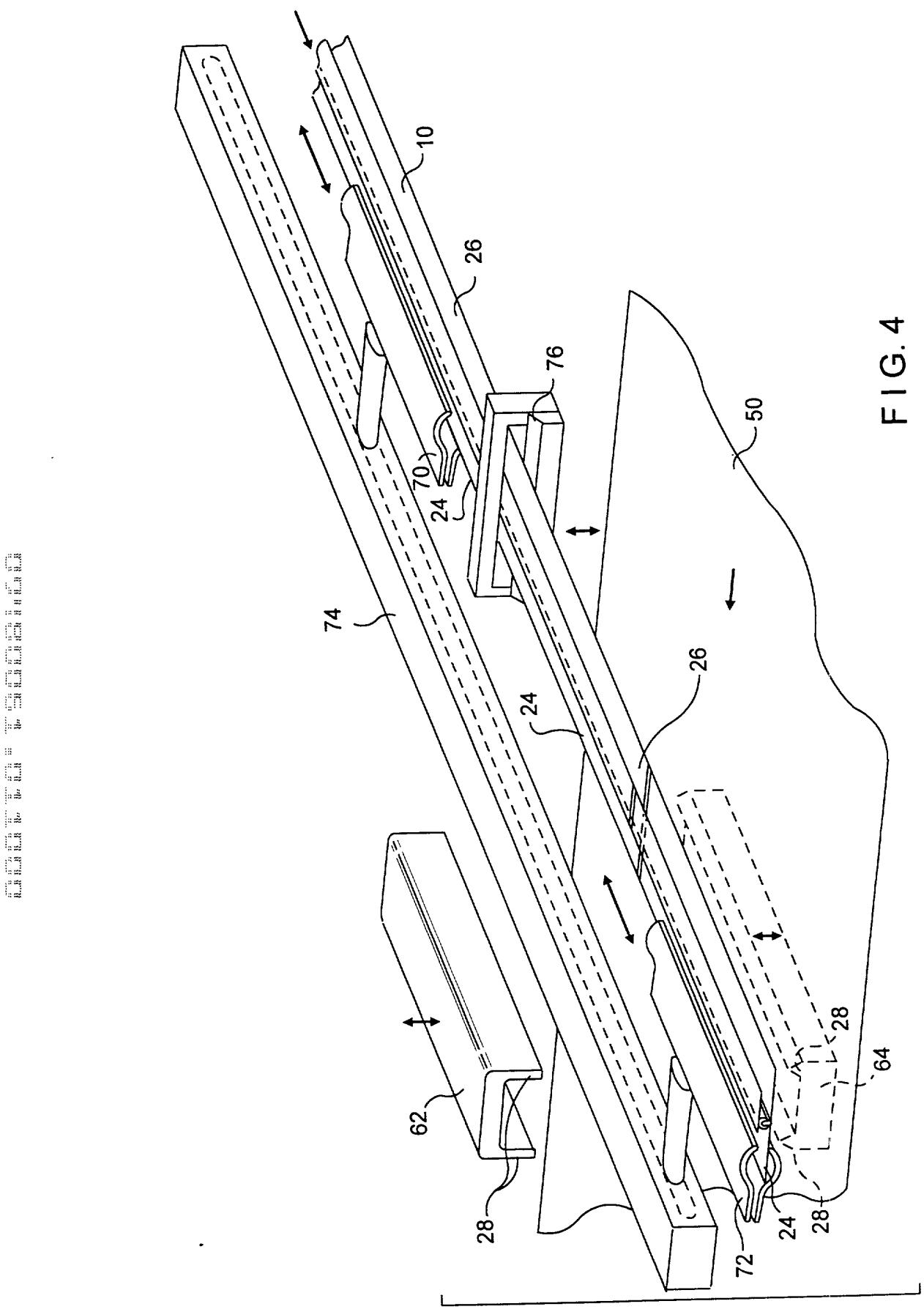


FIG. 5

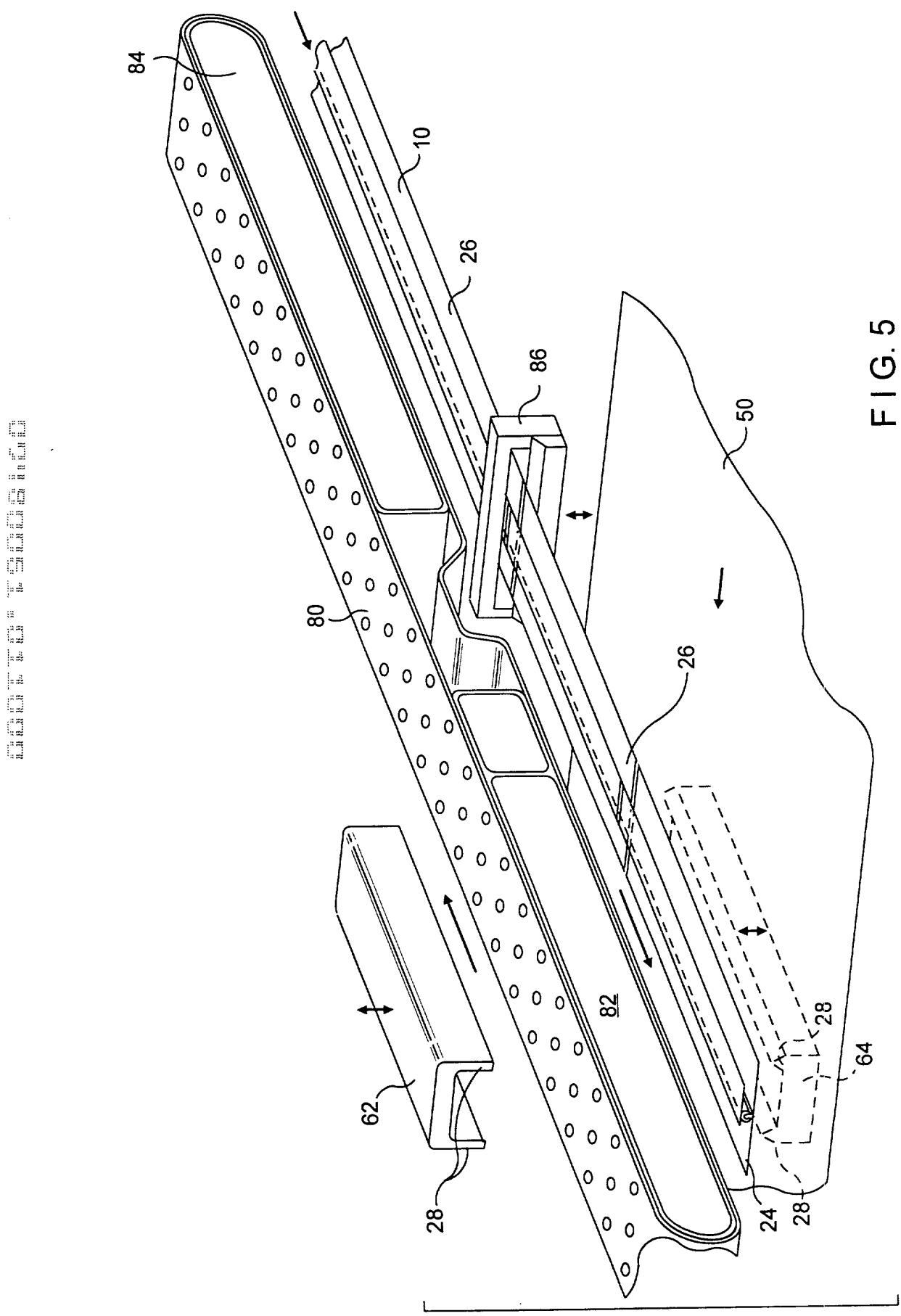
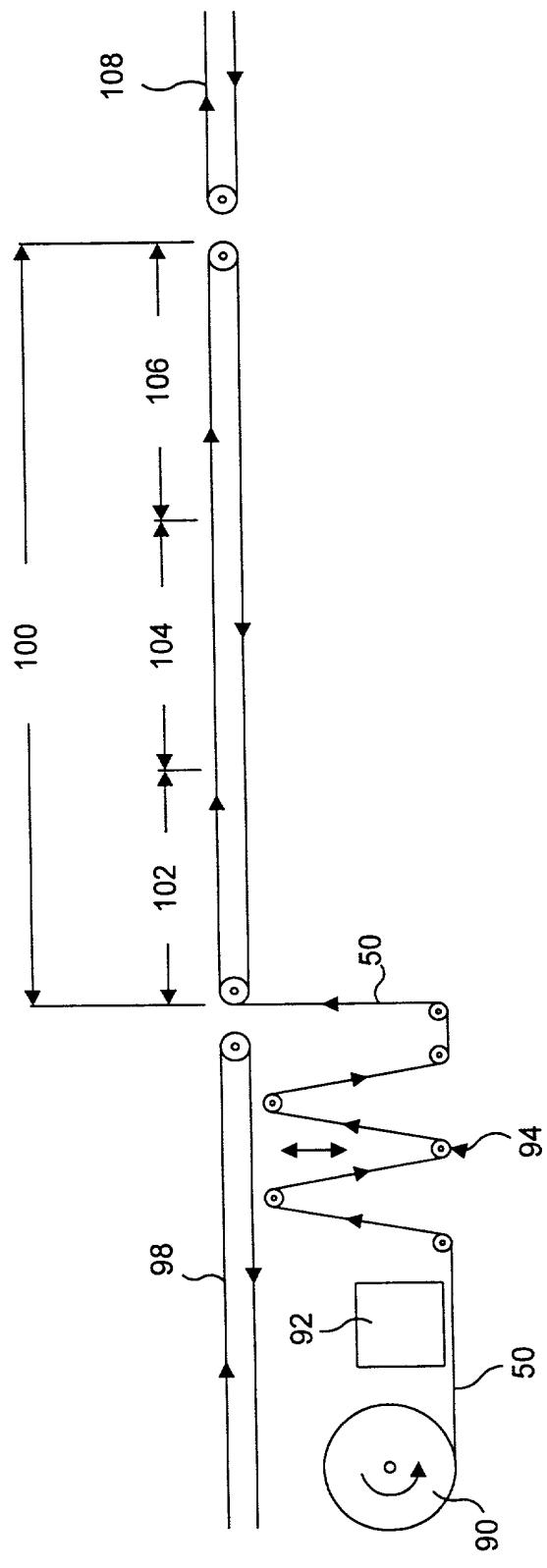


FIG. 6



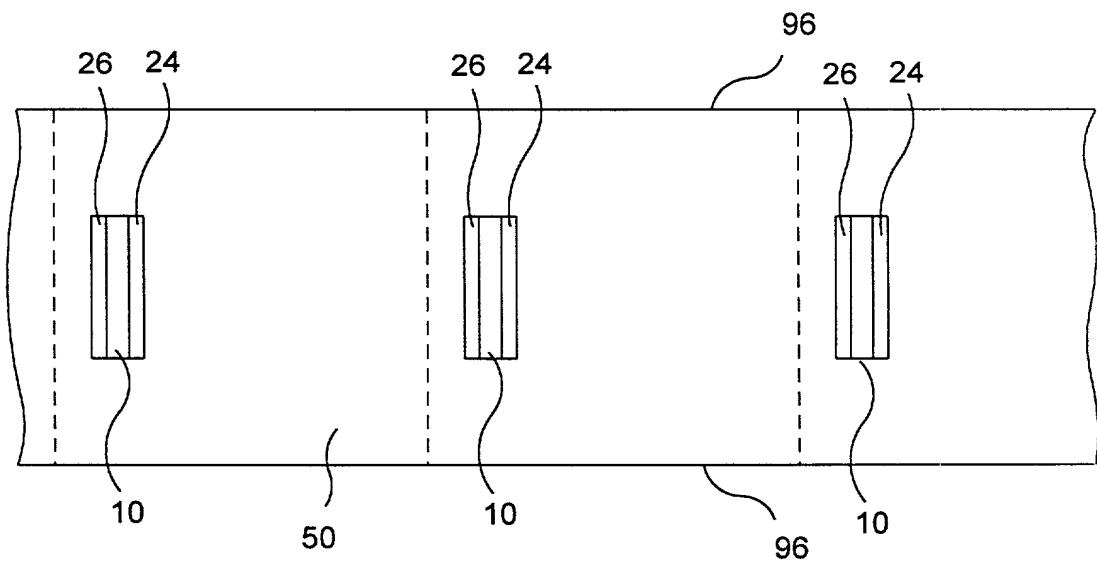


FIG. 7

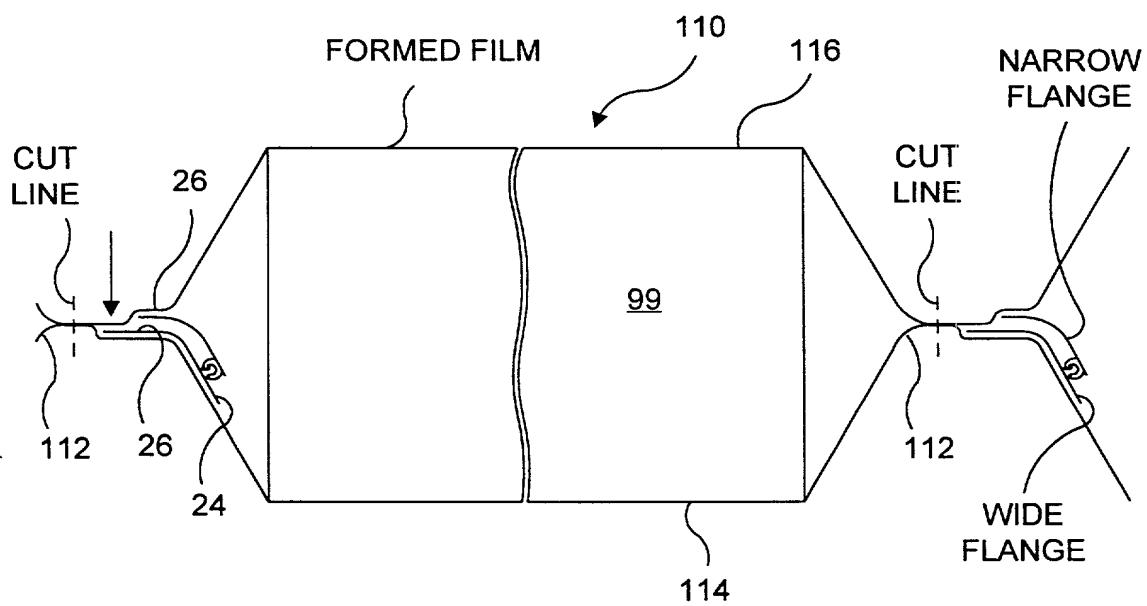


FIG. 8

## **COMBINED DECLARATION AND POWER OF ATTORNEY FOR PATENT APPLICATION**

As a below named inventor(s), I (We) hereby declare that:

My (Our) residence, post office address and citizenship are as stated below next to my (our) name(s). I (We) believe I (we) am (are) the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

ZIPPER STRIP AND METHOD OF POSITIONING THE STRIP TRANSVERSE LONGITUDINAL AXIS, the specification of which is attached hereto unless the following is checked:

— was filed on \_\_\_\_\_ as United States Application  
Number or PCT International Application Number \_\_\_\_\_  
and was amended on \_\_\_\_\_ (if applicable).

I (We) hereby state that I (we) have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I (We) acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, §1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed.

PRIOR FOREIGN APPLICATION(S)				
NUMBER	COUNTRY	DATE FILED		PRIORITY CLAIMED
				YES NO
				YES NO
				YES NO

I (We) hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, §1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application.

APPLICATION NO.	FILING DATE	STATUS
08/651,977	May 21, 1996	PATENTED, PENDING, ABANDONED
		Pending

I (We) hereby declare that all statements made herein of my (our) own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

I (We) hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith: Joseph C. Sullivan, Registration No. 18,720; John Kurucz, Registration No. 18,688; Gerald Levy, Registration No. 24,419; Joseph T. Eisele, Registration No. 25,331; Ronald R. Santucci, Registration No. 28,988; Ronald E. Brown, Registration No. 32,200; John Gulbin, Registration No. 33,180; and Richard J. Danyko, Registration No. 33,672. \*I (We) further authorize my (our) attorney to insert the proper serial number and filing date awarded to my (our) application on this document, above my (our) signature(s).

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**IN THE UNITED STATES PATENT AND TRADEMARK OFFICE**

In re of the application of: Art Malin et al.

Filed: Herewith

For: **ZIPPER STRIP AND METHOD OF POSITIONING  
THE STRIP TRANSVERSE LONGITUDINAL AXIS**

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Assistant Commissioner for Patents  
Washington, D.C. 20231

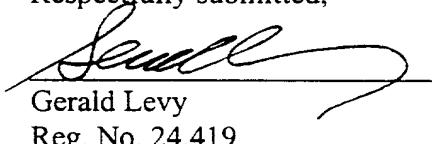
SIR:

I hereby appoint Thomas W. Buckman (Registration Number 25,756), Donald J. Breh (Registration Number 30,159), John P. O'Brien (Registration Number 22,764) and Mark W. Croll (Registration Number 31,098), as my associate attorneys in the above-entitled application, to inspect and prosecute this application, to make alterations and amendments therein, and to transact all business in the Patent and Trademark Office.

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